

Date: Tuesday, 16/12/2008 3:17:46 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B AFT X-TUBE
Job Number	: 44141		
Estimate Number	: 12347		
P.O. Number	:	Part Number	: D206667201
This Issue	: 16/12/2008 S.O. No. :	Drawing Number	: D206-667-241 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 41780	Material	:
Written By	:	Due Date	: 05/01/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 08.12.16</u>		
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:EC		

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



for JUD 09/02/02



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-201 CHG003

08/03/31

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

3.0	D206667201TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B-41779*

NB 08-12-22

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



NB



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT

08-12-22

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------



Comment: DIMENSIONAL CHECK OF X-TUBES

06.12.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/12/2008 3:17:46 PM
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Job Number: 44141

Part Number: D206667201

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576.
(DRILL 3 HOLES ON BOTH SIDES)

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.

4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576

5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs.
(DRILL 3 HOLES ON BOTH SIDES)

6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788

7-C'sink holes as per Dwg D206-667-241

8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241

9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241
Inside of Cuff (Do not engrave on outside of tube)

MB
08-12-22

MB
08-12-23
MB
08-12-22

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB
08-12-23

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MB
08-12-23

P70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-201 PAR #: NIA Fault Category: Prod/x line NCR: Yes No DQA: D Date: 09/04/03
 Resolution: re-work Disposition: re-work QA: N/C Closed: D Date: 05/04/03

NCR: <u>44141</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-01-07	9-0 6-0	Rivet holes are not drilled as per dwg. DT 8787 was used (This is for all other 206 x-tubes) w/o DT #'s are correct. R.C: Lack of Attention by employee & inspector.		Modify the 2x D2872-043/-045 by filling in the rivet holes with weld & grind flush per QSI004 touch-up with Alodine as necessary		see P/E on Page 3 custom nut Plates made 89/3/24 at 09-03-24 89/03/30		09-01-07
				Boil the D2872-043/-045 into position & transfer drill & deburr Touch up with Alodine as necessary. rivet into position after paint. This time only.				09-01-07
				Retrain & notify employee and inspector of this issue				09-01-07

NOTE: Date & initial all entries

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Job Number: 44141

Part Number: D206667201

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 OUTSIDE SERV.11 OUTSIDE SERVICE -CROSSTUBES



7/10: 7923



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

C209/01/08 (1)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

P24/01/08 (1)

12.0 ~~QC6~~ DIMENSIONAL CHECK

QC6



ml 09 01 08

(1)



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

13.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

25 09 - 01 - 08

14.0 QC14 INSPECT SPRAY PAINT



ml 09 01 09

(1)



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

15.0 D3595075395 RUBBER CUSHION .75" x 3.95



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION .75" x 3.95

batch: 37971

cut from 570

25 09 - 01 - 09

16.0 D28911 2.25 Support







Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support 38122

25 09 - 01 - 09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.02.09	22/ 23	PICK QTY(2) D3877-041 NUTPLATE B/N <u>45376</u> QTY(2) D3877-043 NUTPLATE B/N <u>45375</u>	AT	09-03-25		 09.02.09 PC 051042	 09/03/30	
09.02.09	23.1	INSTALL D3877-041/-043 WITH QTY(14) MS20601AD4W10 B/N <u>110219</u>	AT	09-03-25		 09.02.09 PC 051042	 09/03/30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44141

Part Number: D206667201

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 MS2192020 Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp 109715

RT 09-01-09

18.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

A/R Magnabond 6398 batch: 109900

1-Install supports and clamps as per Dwg D206-667-241 and DSI9415. Torque clamps to 80-100 in lb

RT 09 01 09

19.0 QC5 INSPECT WORK TO CURRENT STEP



Ensure PTO 9.0 ± 6.0 is completed



Comment: INSPECT WORK TO CURRENT STEP

5 2/3/30 (K)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 AN532A Bolt



M110363



(K)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

9/3/30

SO

22.0 D2872043 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

SEE W/D CHG

Qty Part number Description Batch

2 D2872-043 Nut Plate

23.0 D2872045 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

SEE W/D CHG

Qty Part number Description Batch

2 D2872-045 Nut Plate

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: 206B AFT X-TUBE

Job Number: 44141

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN510A

Bolt



POSITIVE RECALL



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M110363

EFFECTIVE 09.02.05

AUTH UP

RELEASED

DATE 09.03.24

PER ECU 09.839

25.0

AN530A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-30A

Bolt

M109061

26.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

20 AN960JD516

Washer

M110503

27.0

MS21042L5

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 MS21042L5

NUT

M110382

9/3/30

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-201

Location:

PPP Rev:

RevC

8/09/03/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 44141

Part Number: D206667201

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WUF
09-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

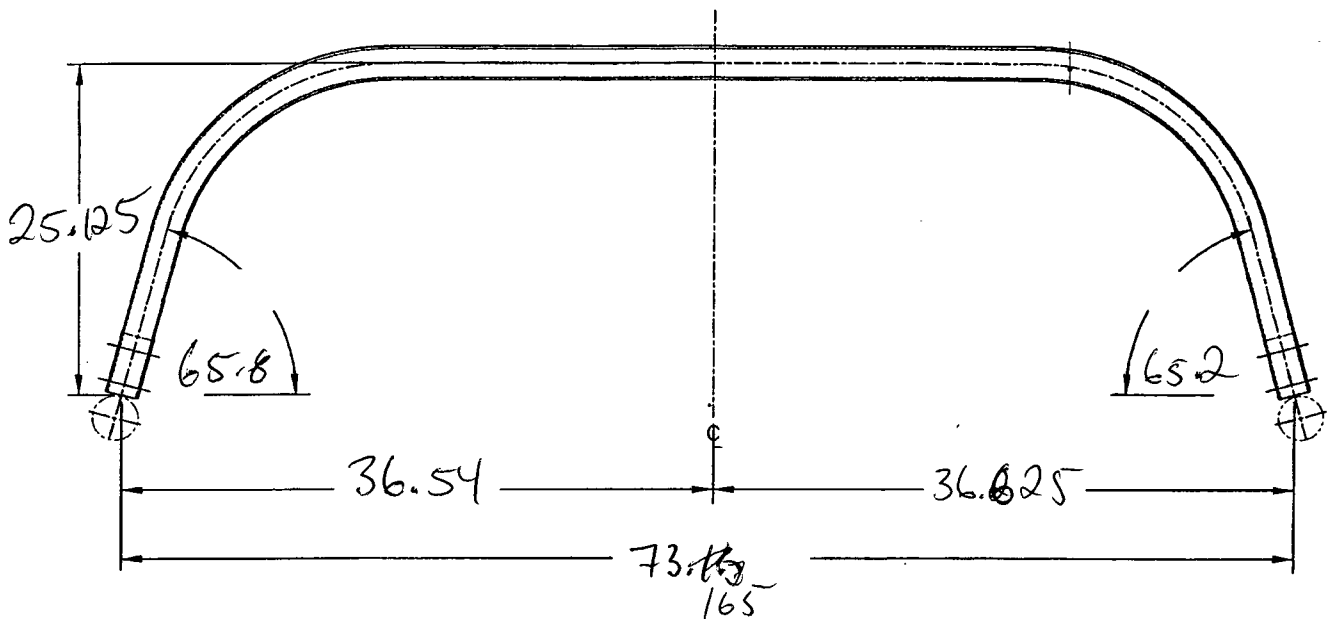
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44141
Description: Crosstube High Aft (206B)		Part Number: D206-667-201
Inspection Dwg: D206-667-241 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	24.98	25.10
1/2 Span	36.54	36.66
Angle	65	67
Total Span	73.08	73.32



Comments

QC15 Inspection	<i>[Signature]</i> 06-12-02
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.12.04	24-98 was 24.48	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 22.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/12

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WORK ORDER
NO. 4141

C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-241	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

8

7

6

5

4

3

2

1

D

C

B

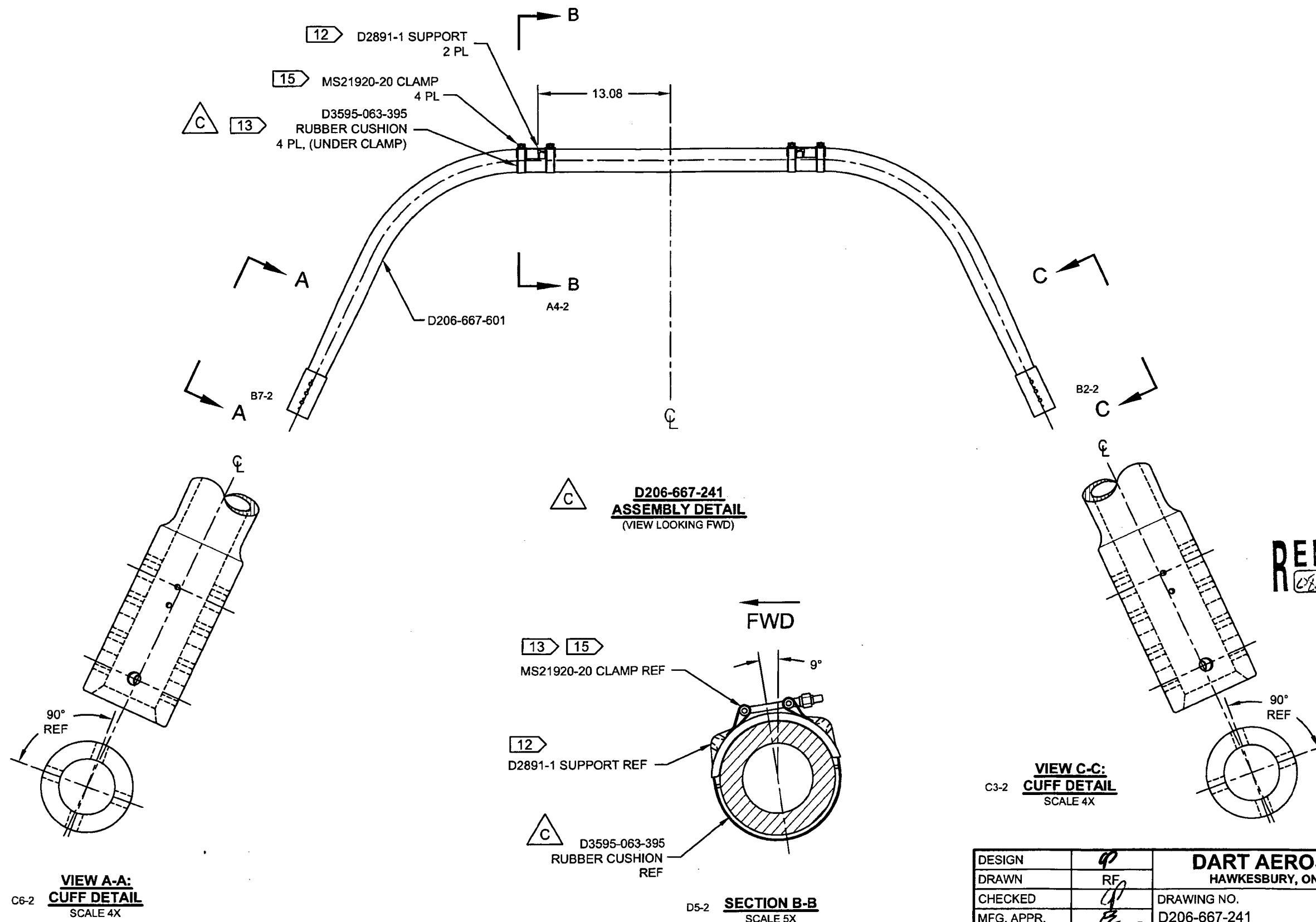
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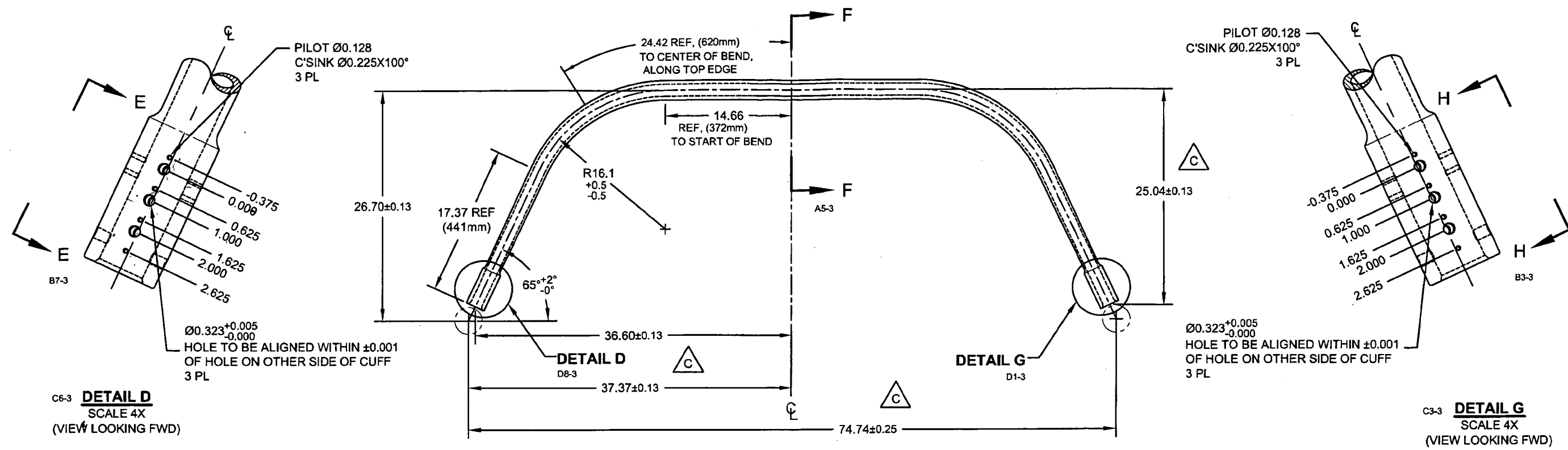
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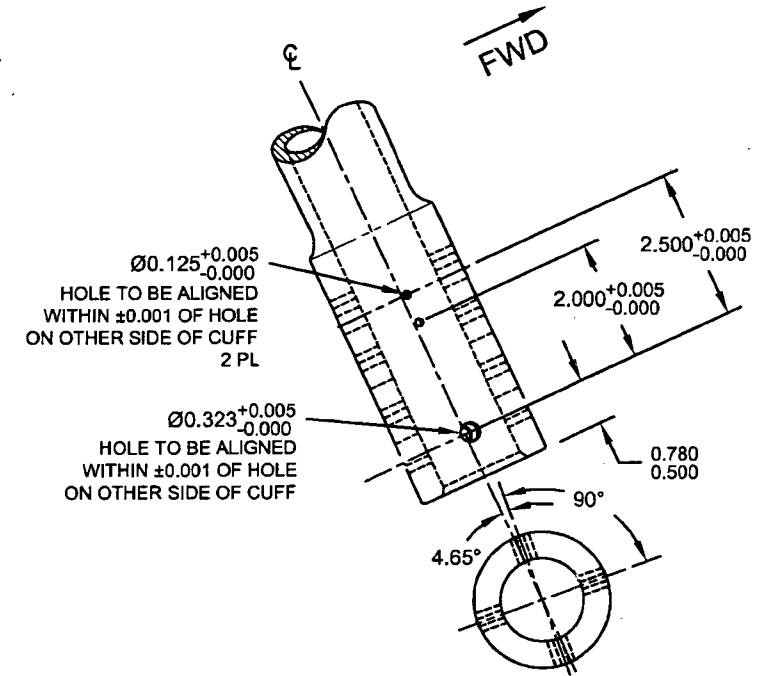
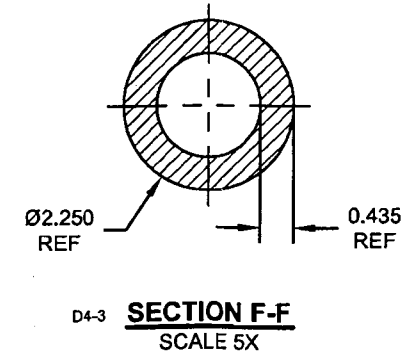
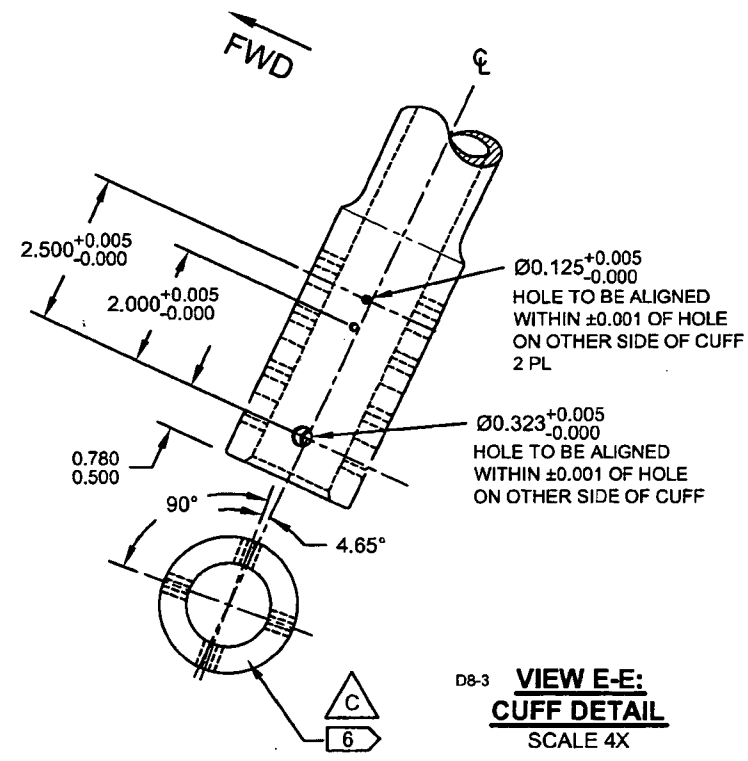
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. C
MFG. APPR.	90	D206-667-241	SHEET 2 OF 4
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DE APPR.	90	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
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D206-667-601
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)



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08/11/06

VIEW H-H:
CUFF DETAIL
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WORK ORDER
NO. 4414

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	EF	D206-667-241	SHEET 3 OF 4
APPROVED	MF	TITLE	SCALE
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B

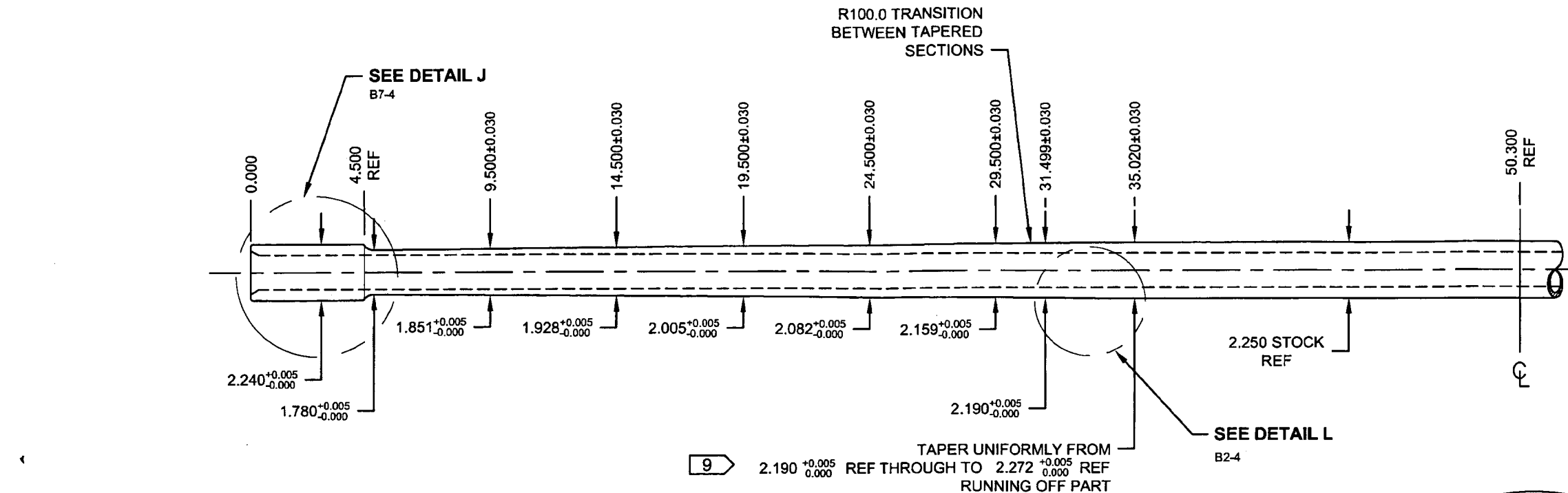
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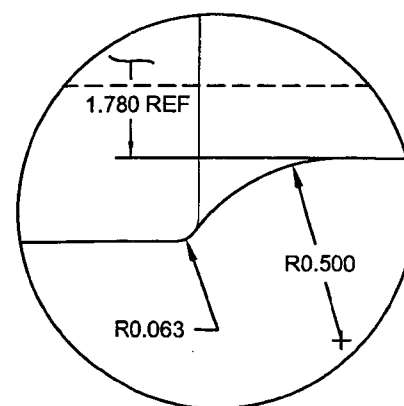
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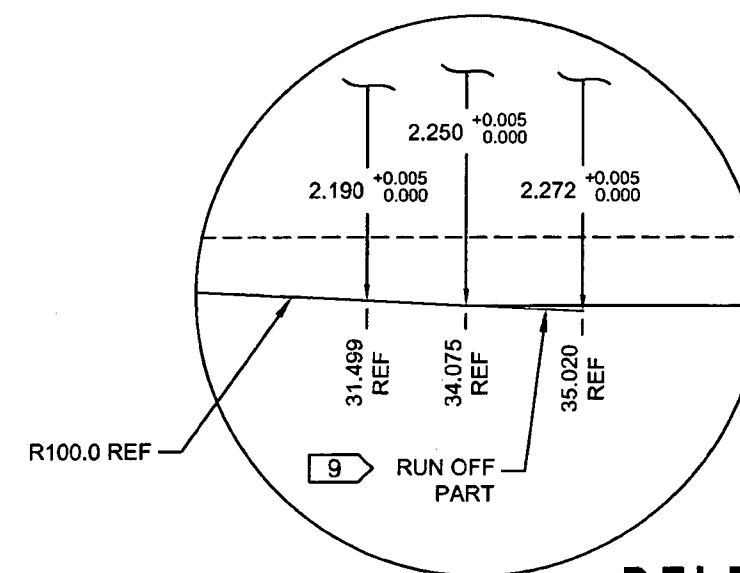
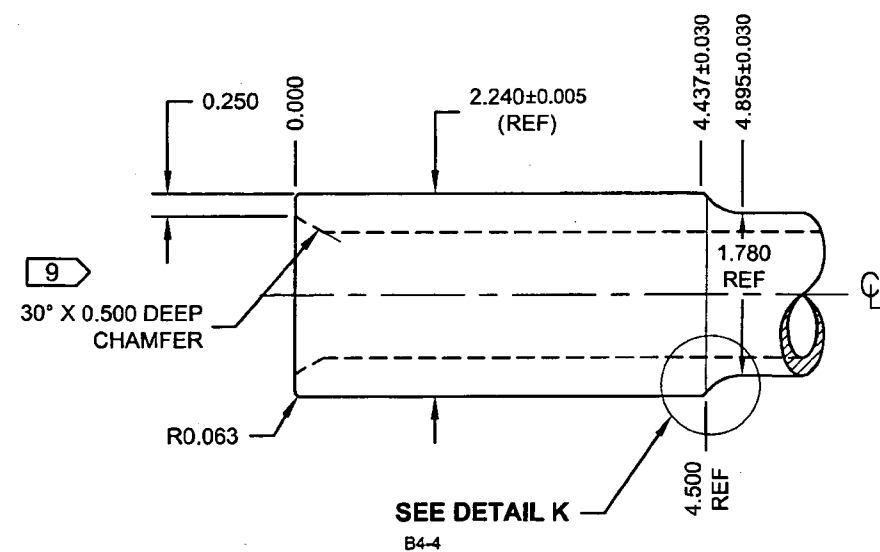
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TURNING DETAIL



**DETAIL K:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL L:
TAPER RUN-OFF**
NOT TO SCALE

DESIGN	92	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-241	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
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20/11/12

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NO 44191



LIQUID PENETRANT TEST REPORT

P- 09135

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Jan 7, 2009 TIME AM ☐ PM ☐
ATTENTION Linda Lacelle ACUREN JOB No. 188-08-1660
ADDRESS 1270 Aberdeen St. POWO No. 7923
Hawkesbury, Ont, K6A 1K4 WORK LOCATION Hawkesbury
ACCEPTANCE STD. ASTM 1417-03 REV./DATE 2005
PROJECT 206 BAFT X-TUBE, 206 FWD X-TUBE, 212/205 HIGH AFT X-TUBE ASSEMBLY
ITEM(S) EXAMINED Job #'s 44141, 44142, 44137, 44138, 44212, 44213

JOB DESCRIPTION PROCEDURE No. LT-002 REV./DATE TECHNIQUE No. LT-002 REV./DATE
PART No. D206667201, D206667103B, D212664201 MATERIAL ALODINE ALUM. THICKNESS N/A
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON
100% external surface

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAPLUX BLACK LIGHT S/N B171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT MINIMUM DWELL TIME 30 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H₂O MINIMUM DRY TIME >10 MIN. OTHER CAL FGB09
DEVELOPER SKPS3 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
44137	Acceptable	✓	
44138		✓	
44141		✓	
44142		✓	
44212		✓	
44213		✓	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Jan Titley DTR #
TECHNICIAN (SIGNATURE): Frederick Chagnon REPORT REVIEWED BY:
NAME (PRINT): Frederick Chagnon NAME INITIALS
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL II SNT LEVEL II CGSB LEVEL SNT LEVEL
CGSB REG. No 10560 CGSB REG. No

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: March 24/09	Job No.:	ADR Yes/No: Y	ADR Date:	ECN #: 09- 539
Product No.: D206-667-201		Created By: MP	Approved By:	
Product Name: B206 crosstube		Checked By:	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	
Production Document Control	Y	JLD	
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator			
Marketing	Y	SW	
Customer Order Processing			

Reason for Change: CROSSTUBES MIS-DRILLED. DSI CREATED TO CREATE CUSTOM NUTPLATE TO SALVAGE TUBES

Documents Affected:
 CREATED DSI 9442 REV. APPLICABLE TO B/N 44214 AND B44215 ONLY
 CREATED DWG D3877 REV A

PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.03.24
9	Update Blue/Pink/DSI Folder and Electronic Files	N	KJ		
10	Update Controlled PDF Files	Y	KJ		09.03.24
11	Update Master Document List (MDL)	Y	BP	Rev. H	09.03.24
12	Update Document Record (DR)	Y	KJ	Rev. N	09.03.24
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	Y	KJ		09.03.24
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	N			
18	Create / Update PPP's	N			
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.03.24
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.03.24
22					
23					

Description / Action:

RELEASE DSI 9442 REV A AND DWG D3877 REV A
 THIS DSI IS ONLY APPLICABLE TO B/N B44214 AND B44215.

ECN Verified & Complete: _____ Date: _____